

Work Order ID 67365



Page 1

Wednesday, March 16, 2011 12:56:58 PM

Item ID:	D3043-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Weldment RH, A119					
Start Date:	3/17/2011	Start Qty:	4.00	Cust Item ID:		
Required Date:	3/29/2011	Req'd Qty:	4.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	<i>11-03-16</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3043	Rev A								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G□□2-Deburr and bevel ends for welding								

11.04.06 4 0

110		0.00							
	QC - Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

11.04.12

120		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808□AR AL ROD Batch: <i>114703</i> □2-Grind Fwd End Cap weld flush <i>115928</i>								

11.04.14 4 0

AE 11.04.15 (x4)



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Item ID: D3043-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment RH, A119

Start Date: 3/17/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0 BB 11/04/26

140

QC5- Inspect part completeness to step on W/O

0.00



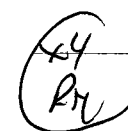
QC

Memo

0.00

Quality Control

8 11/04/26



150

Chemical Conversion Coat per QSI005 4.1

0.00



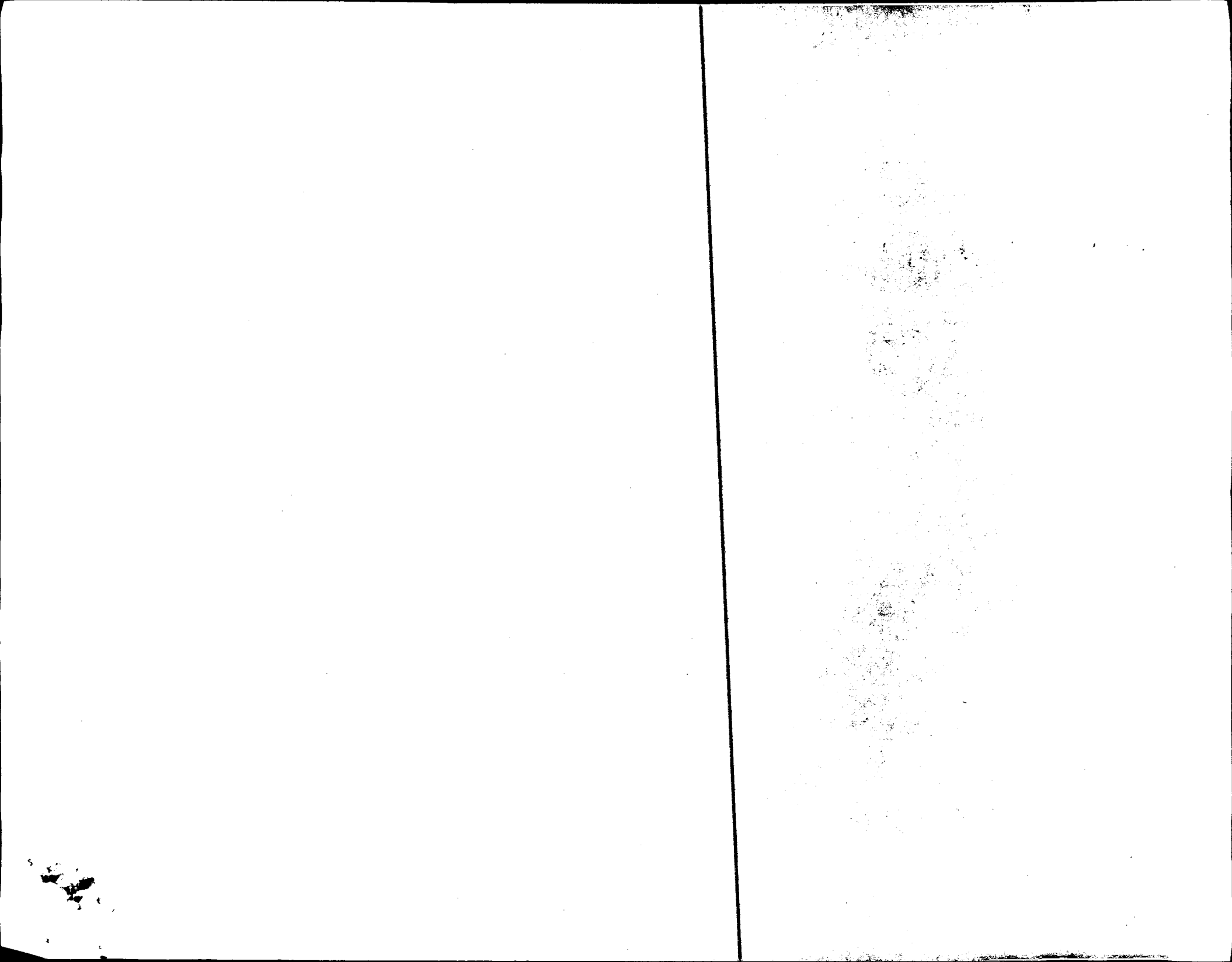
HandFinish

Memo

0.00

Hand Finishing

x4RH 0 11/03/03



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Page 3

Accept

[illegible]**Setup Start**[illegible]

Stop

[illegible]**Cust Item ID:**

Start Date: 3/17/2011 **Start Qty:** 4.00

Required Date: 3/29/2011 **Req'd Qty:** 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Abstract

QC:

Date:

SPC (Y/N):

Date:

Stop



**Insp.
Stamp**

0.00

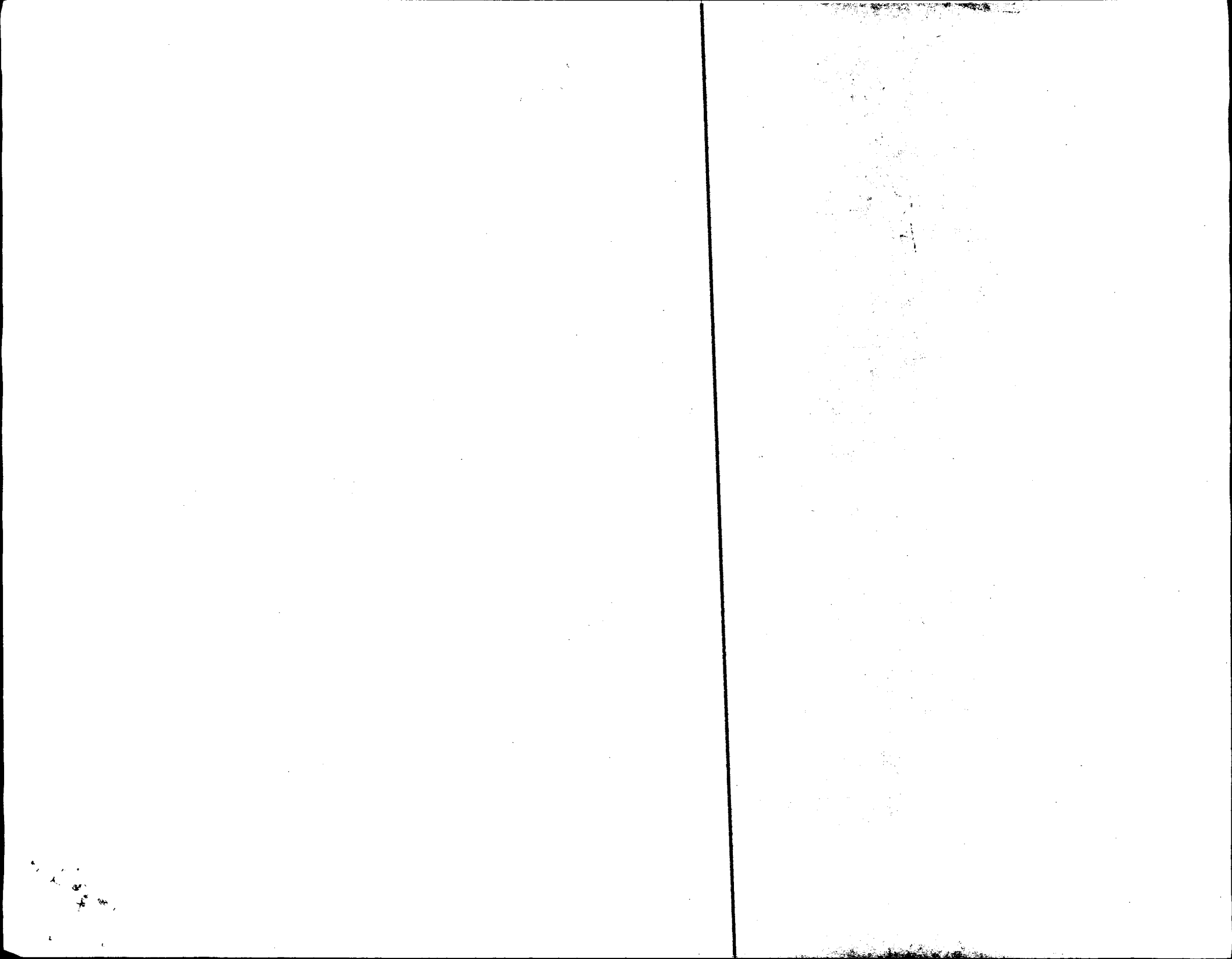
1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043 ☐ AR AL ROD
Batch: M114703 ☐ 2-Inspect for foreign object as per QSI 024 ☐ 3-Grind
Fwd End Cap weld flush

0.00

0.00

0.00

0.00



Dart Aerospace Ltd

W/O: 67365		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/05/09	215	Wingwalk as per dwg QSI0054.4 Batch: M117315	[Signature]	11/05/09	X1 RA	[Signature]	

Part No: D3043-042 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67365

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Item ID: D3043-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment RH, A119

Start Date: 3/17/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

m.k 11/05/05/ (4XRH)

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

SAD 11-05-06 (4)

210

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

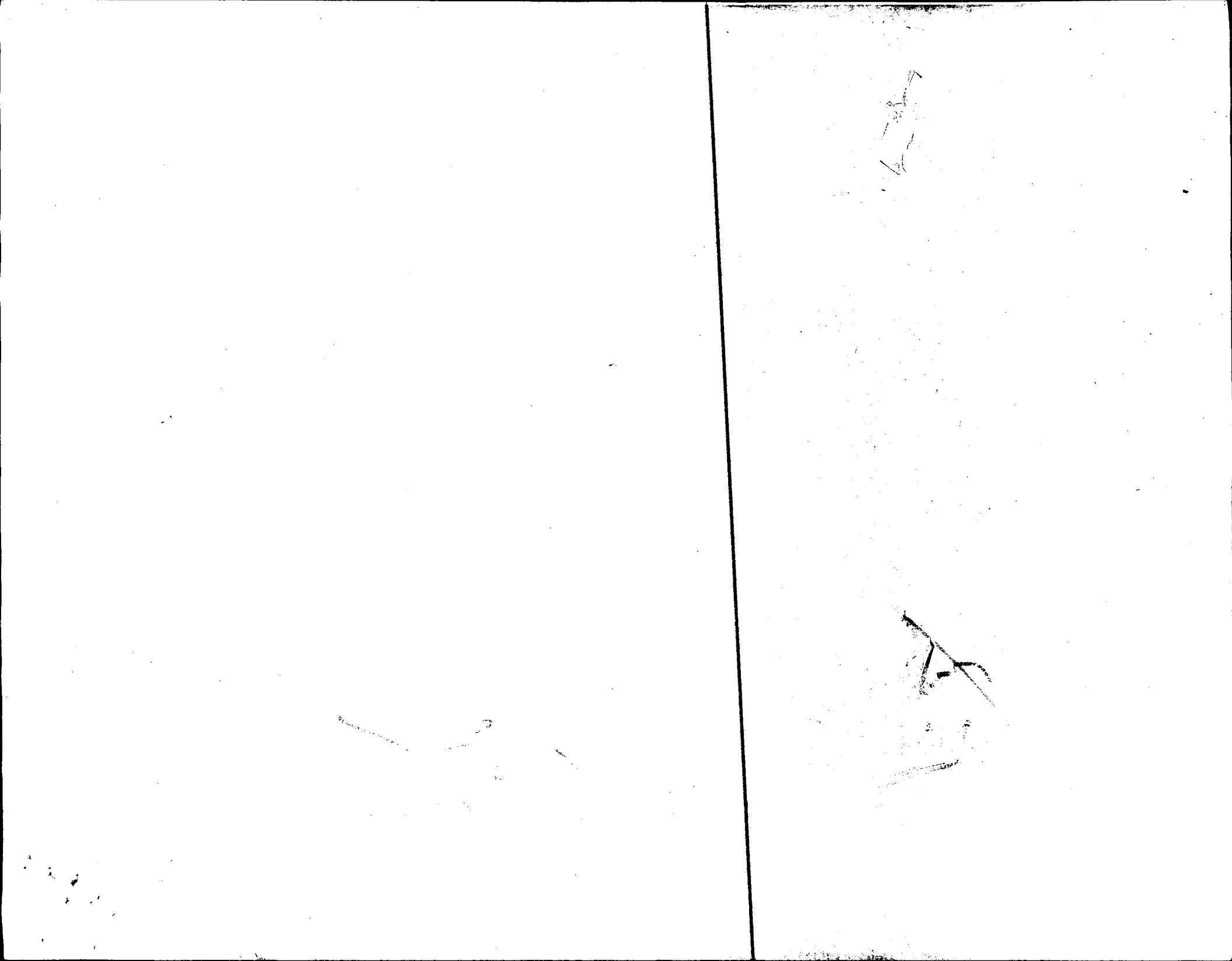
320

9:40

10:10

(4RH) m.k 11/05/07






M116964







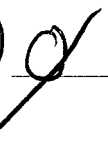


Work Order ID 67365

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Item ID: D3043-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Step Weldment RH, A119
Start Date: 3/17/2011 Start Qty: 4.00  Cust Item ID:
Required Date: 3/29/2011 Req'd Qty: 4.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							  11/05/07
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							H BR 11-5-9
240  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							PP 67363 11/5/10 sf



Work Order ID 67365

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Item ID: D3043-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment RH, A119

Start Date: 3/17/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11

66 6609.11

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Page 1

[illegible]

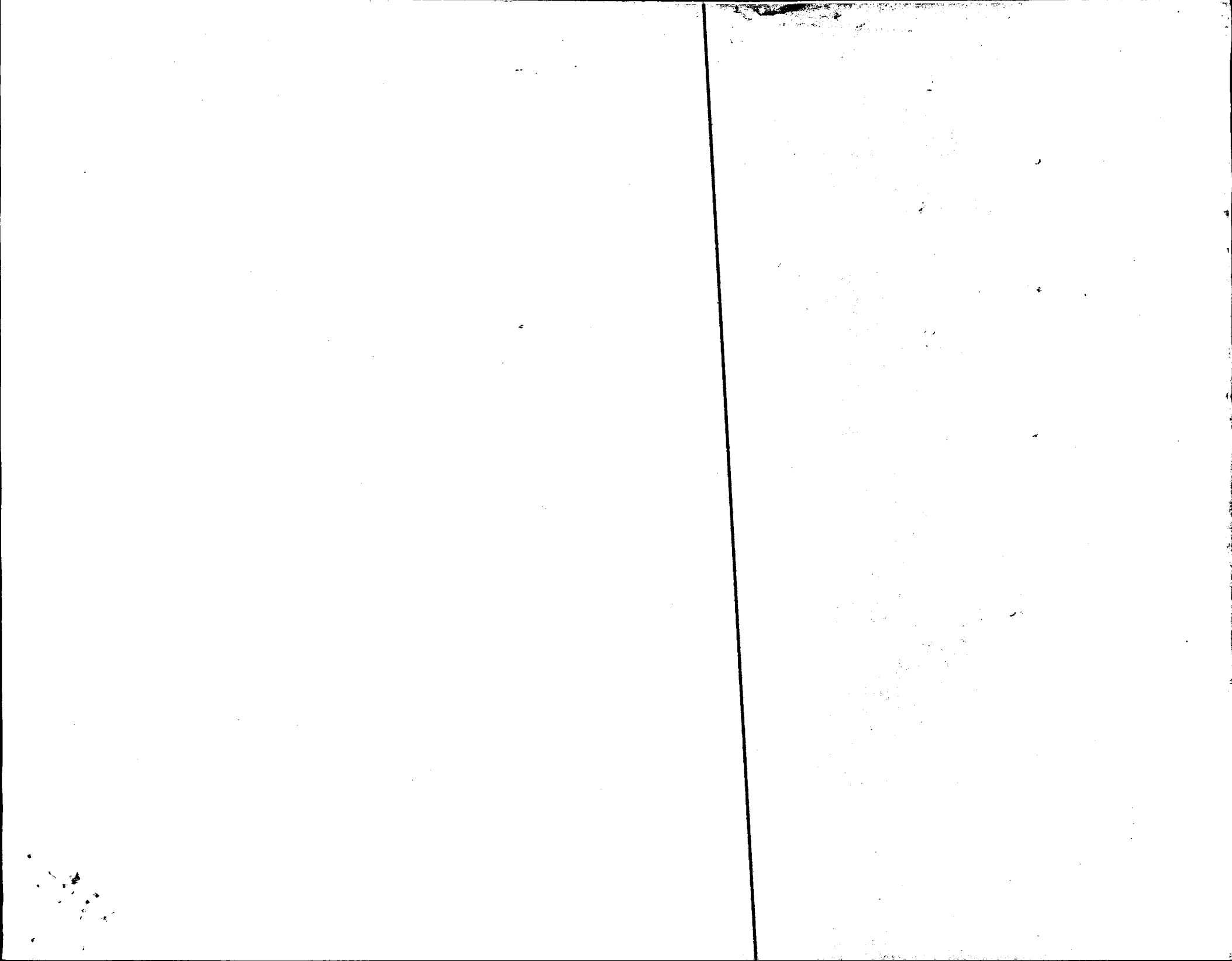
00000000000000000000000000000000

Required Date: 3/29/2011

Required Qty: 4.00

Comments: IPP Rev :A New Issue JLM 05-11-01

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA018	34	
48240	34	





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3043	REV. A SHEET 1 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT SCALE NTS	
A	01.06.28	NEW ISSUE	

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D3043-041	STEP WELDMENT, LH
	X	D3043-042	STEP WELDMENT, RH
1	1	D2622-120	STEP EXTRUSION
2	2	D3040-1	MOUNTING LUG
2	2	D3040-3	MOUNTING LUG
2	2	D2734	ENDPLATE

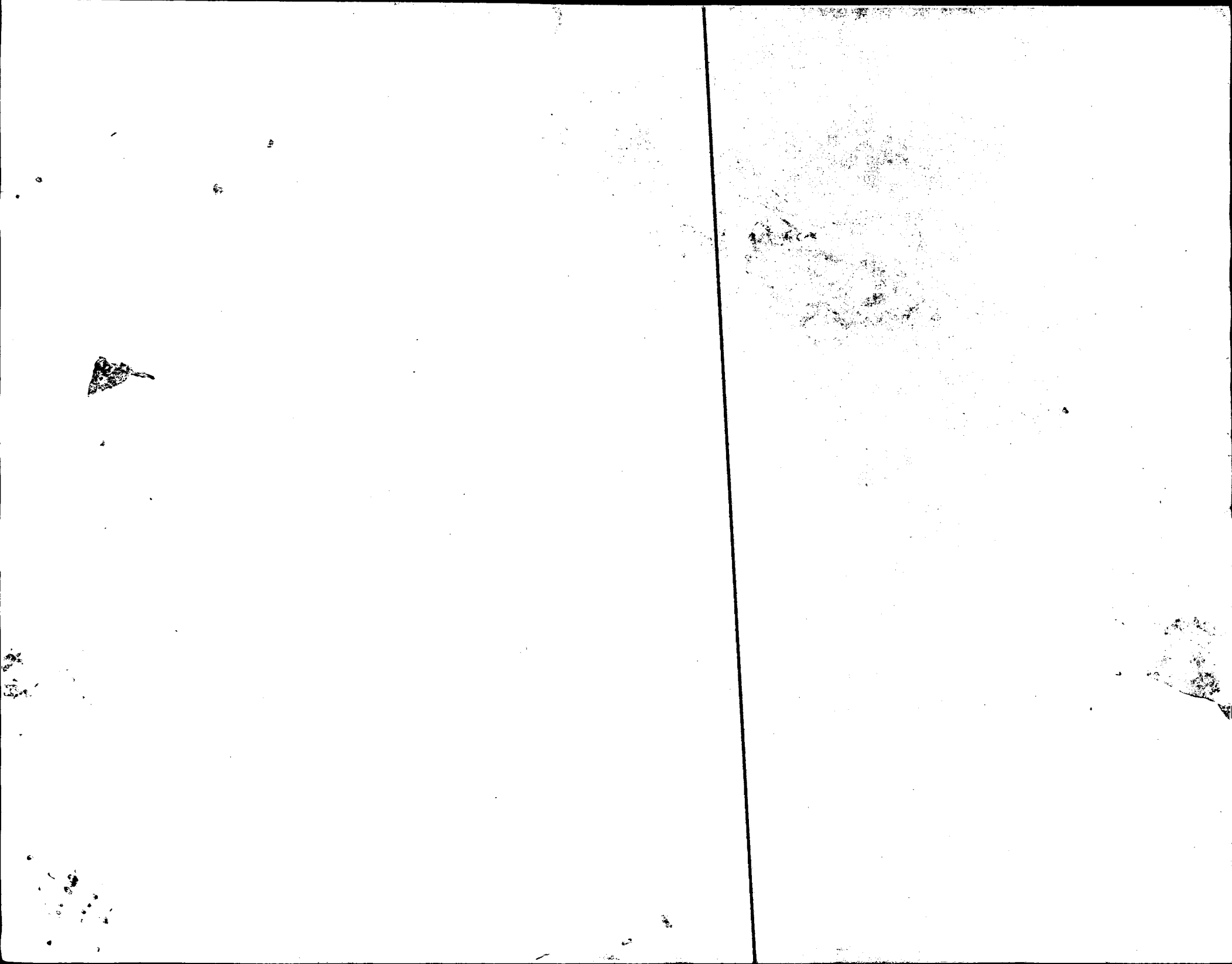
NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

#67365
RELEASED
01.07.05 *[Signature]*

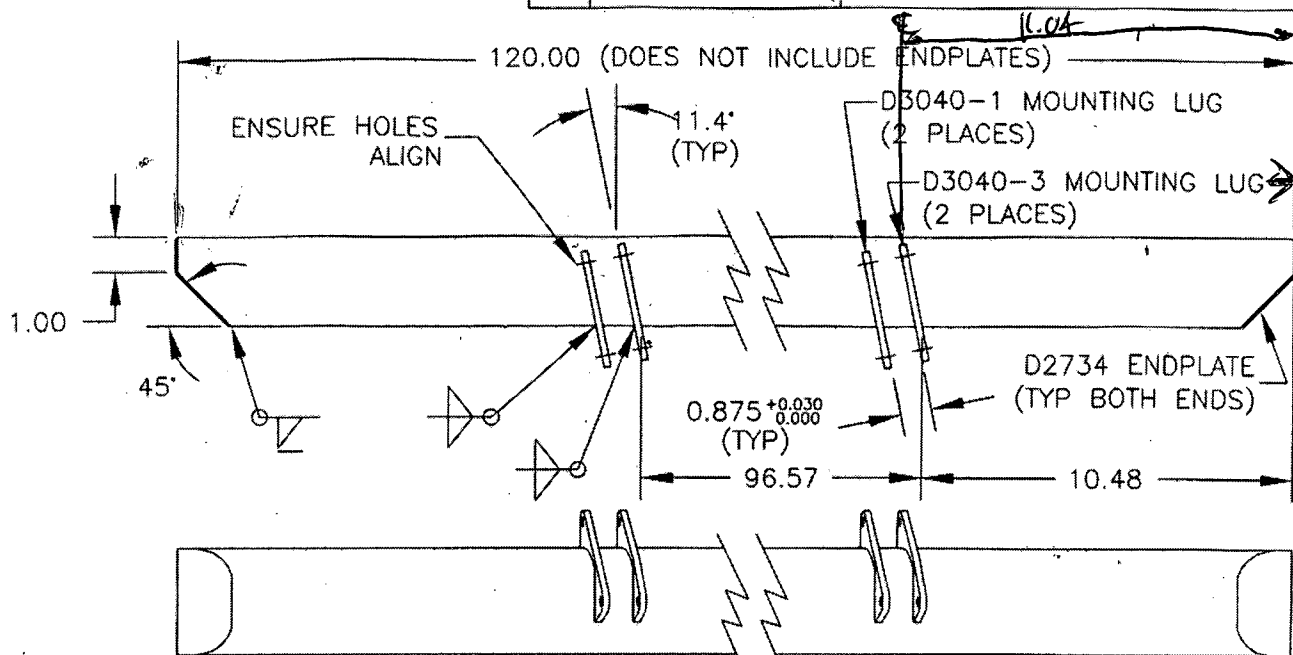
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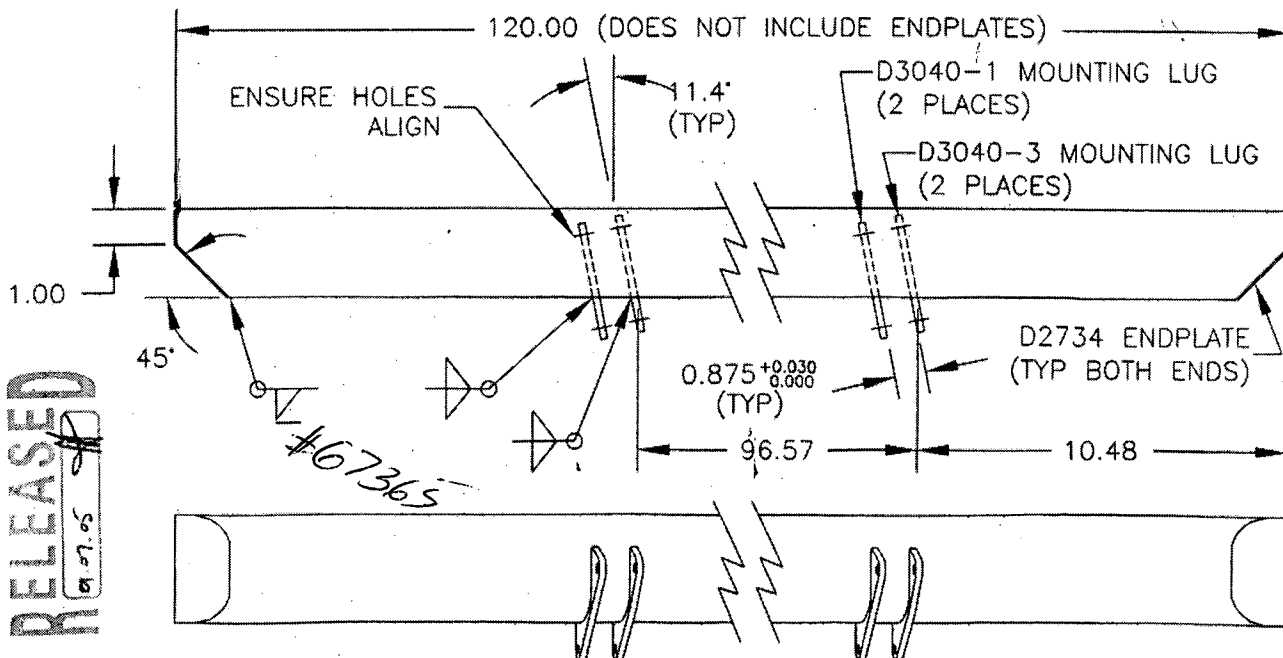




DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28	TITLE A119 STEP WELDMENT		SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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9/27/05

